B85317 D407-667-205 X

Folio 21

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Jigs/Fixtures/Tooling

Kit Incorrect

Kit Missing

Part Lost

Part Moved

Raw Material

Türning Sequence Wave/Twist in Tube

Torque Waves in Extrusion

Ovalized

Too Many

Over/Undersized

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

130

130

Memo

QC15- Crosstube Dimensional Check

Quality Control

NCR: Y	es	/ No				WORK	ORDER NON-	COI	NFORM	MANCE / UPI	DATE		_			.4
													QA Closed:	Da	ate:	.
Work Orde	r:						DISPOSITION				AGAINST	DE	PARTMENT/	PROCESS		· ·
Part N NCR N	o					Wor	Rework Scrap Use-as-is k Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			d. Eng. Coor. e/Packaging Supplier Other		Engineering Quality
Root					Descr	iption of w	ork order update		nitial		ion		Sign &			
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6.01	-	Ripples or Torgue W			n *	Ovalized		-	4	tures/Tooling	Jiicleal	-	Part Lost	COICHAILCE	_	
		Turning S				Over/Und	ersized		Kit Inco				Part Moved			

Kit Missing

DQA:

Raw Material

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

Wave/Twist in Tube

ાં Too Many

85317

Page 3

June-05-12 3:36:59 PM

Item ID:

D407-667-205

Accept

N900040100

Setup Start

NQ1

Revision ID:

Start Date:

Item Name: Crosstube Aft

Required Date: 19/06/2012

05/06/2012

Start Qty: 1.00 Reg'd Oty: 1.00 *1*

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan

_____ Date:

__ Tooling:

Date:

Start

NR1

OC:

- 1 -

Date: ____

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool #

Reject

Qty

Run

Accept

Qty

*NR2

Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

140 *140*

Crosstubes

Operation

Description

Crosstubes Crosstubes

Memo

0.00

0.00

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245

6-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Note: Aft side has 3x top holes.

7-Drill Fwd rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Drill only the top (3) holes.

8-C'sink holes as per Dwg D407-667-245. Allow rivet to sit below surface to compensate for paint.

9- Scribe tube to identify on the inner chamfer in the cuff D# and B#

10-Deburr & Inspect for surface damage. Repair damage within limits as per

Km/mo

Plan

Code

12-7-19

1.01

										DQA	: Da	te:	
NCR: Y	es / No				WORK ORDER NON-	CONF	FORN	MANCE / UPI	DATE		_		
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Landin	g Gear				Hardware			General		7		_	
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	Ripples o	n Inner B	end		Misaligned	I	nstructi	ons Incomplete/L	Inclear	Over/Unde	r tolerance		

Jigs/Fixtures/Tooling

Kit Incorrect

Kit Missing

Part Lost

Part Moved

Raw Material

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

Turning Sequence Wave/Twist in Tube

Torque Waves in Extrusion

Ovalized

Too Many

Over/Undersized

Work Order ID 85317 Page 4 June-05-12 3:36:59 PM Item ID: D407-667-205 Accept *N900040100* Setup Start **Revision ID:** Item Name: Crosstube Aft **Start Date:** 05/06/2012 *1* Start Qty: 1.00 Cust Item ID: **Required Date:** 19/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: ____ Date: ____ Approvals: **Tooling:** Date: QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Oty Number Stamp Dwg D407-667-245 150 Crosstubes Chemical Conversion CZ 1210)/20 0 *150* HandFXtube Memo Hand Finishing Crosstubes 160 QC3- Inspect Part Finish 0.00 *160* QC 0.00 Memo Quality Control 170 QC5- Inspect part completeness to step on W/O 0.00 *170*

0.00

Memo

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QC

Quality Control

NCR: Y	es / No				WORK ORDER NON-O	CON	VFOR	MANCE / UP	DATE			_		
											QA Closed:	Da	te:	
					DISPOSITION				AGAINST DI	ΕP	ARTMENT/	PROCESS		
Work Ordei	r:				Rework	1		Skid-tube	Crosstube	٦	Proc	d. Eng. Coor.		Engineering
Part No	o				Scrap]	1	Machining	Small Fab		Rec/Stor	e/Packaging		Quality
					Use-as-is]	Thern	noforming	Finishing	╛		Supplier	_	1 1
NCR N	o				Work Order Update	╛		Large Fab	Composite			Other	L	
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Landin	g Gear				Hardware			General						
	Bending	Passes Be	low Mi	n [Breaking		Burrs			٦	Maintenand	ce		Set-up
	Centre N	ot Conce	ntric to	o/s	Missing		Contam	ination			Mislabeled			Supplier
	Cracks				Size/Length		Cut Too	Short			Off-Set			Temperature/Cure
_	Crushed	Crimp at	Bendin	g \lceil	Spinning		Docum	entation/Data			Orientation I	Misread		Weld
	Inspection	n Strip in	Tube		Threading		Finish				Out of Calibr	ation		Wrong Stock Pulled
	Other				Wrong		Inspect	ion Incomplete			Out of Seque	ence		_
	Positione	ed Wrong	;		Drill Holes		Inspect	ion Unqualified			Outside Dim	ensions		Other
Γ	Ripples	n Inner B	end		Misaligned		Instruct	ions Incomplete/l	Unclear		Over/Under	tolerance	_	
	Torque V	Vaves in I	Extrusio	n 🗌	Ovalized		Jigs/Fix	tures/Tooling			Part Lost			
	Turning S	Sequence			Over/Undersized		Kit Inco	rrect		١	Part Moved			

Kit Missing

DQA:

Raw Material

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

Wave/Twist in Tube

Too Many

QC

Quality Control

June-05-12 3:36:59 PM Item ID: D407-667-205 Accept *N900040100* Setup Start **Revision ID:** Item Name: Crosstube Aft **Start Date:** 05/06/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 19/06/2012 **Req'd Qty:** 1.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 180 Outsource process NDT per QSI038 4.1 0.00 *120* Outsource2 Outsource process - NDT Liquid Penetrant Inspection as per QSI 038O LNI as per ASTM 1417 Level 2 Attach copy of NDV results to work order 190 0.00 *190* Packaging Packaging 0.00 Memo Packaging Ensure copy of NDT results attached to work order. 200 QC5- Inspect part completeness to step on W/O 0.00 *200*

0.00

Memo

	•									DQA.	Date.	
NCR: Y	'es / No				WORK ORDER NON-O	CON	IFORM	MANCE / UP	DATE	QA Closed:	Date:	•
1					DISPOSITION				AGAINST DE			
Work Orde				····	Rework]		Skid-tube Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	Engineering Quality
Part N NCR N					Scrap Use-as-is Work Order Update		Therm	noforming Large Fab	Finishing Composite	Rec/Stor	Supplier Other	Quality
Root				Descri	ption of work order update	ln	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Offset/Setup Other Process Supplier								nd s				
Training Unauthorized												
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Landir	ng Gear		· · · · · ·		Hardware			General				
	Bending I Centre N			<u> </u>	Breaking Missing	-	Burrs Contam	ination		Maintenan Mislabeled	ce	Set-up Supplier
	Cracks				Size/Length	Щ	Cut Too	Short		Off-Set		Temperature/Cure
	Crushed/	•		<u> </u>	Spinning	1		entation/Data		Orientation	<u> </u>	Weld
	Inspectio	n Strip in	Tube		Threading	-	Finish		<u> </u>	Out of Calib		Wrong Stock Pulled
	Other				Wrong		•	on Incomplete		Out of Sequ		7
	Positione	_		_	Drill Holes	-		on Unqualified		Outside Dim		Other
	Ripples o	n Inner B	Bend		Misaligned		Instruct	ions Incomplete/	Unclear	Over/Under	tolerance	

Jigs/Fixtures/Tooling

Kit Incorrect

Kit Missing

Part Lost

Part Moved

Raw Material

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Ovalized

Too Many

Over/Undersized

PAINT: 122381 Start Time: 6:00 Finish Time: 7:00 } All 12-7-24

220

QC14- Inspect Spray Paint

0.00

220

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

DAS 16 9-69

17/04/24

										DQA:	Date:	•
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Part N	lo				Scrap	1			Small Fab		e/Packaging	Quality
raitiv					Use-as-is	┧┃┰		noforming	Finishing		Supplier	'
NCR N	lo.				Work Order Update	1		~ -	Composite		Other	
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Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Descript	ion	Date	Verification	QC Inspector
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Unauthorized	<u> </u>			<u> </u>		AULT (CATE	GORY				
Landii	ng Gear		•		Hardware	AULI	CAIL	General				
Lanuii	·	Passes Re	elow Mi	, [Breaking	Пви	ırrs	30,,0.2.		Maintenan	се	Set-up
	Bending Passes Below Min Centre Not Concentric to O/S				Missing	\vdash		ination		Mislabeled		Supplier
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	Other	-			Wrong	Ins	specti	on Incomplete		Out of Sequ	ence	-
	Position	ed Wrong	3	<u> </u>	Drill Holes	Ins	specti	on Unqualified		Outside Dim	ensions	Other
**	Ripples	on Inner E	Bend		Misaligned	Ins	struct	ions Incomplete/Unc	lear	Over/Under	tolerance	
	Torque \	Naves in	Extrusio	n 🗀	Ovalized	Jig	s/Fixt	cures/Tooling		Part Lost		

Kit Incorrect

Kit Missing

Part Moved

Raw Material

Turning Sequence

Wave/Twist in Tube

Over/Undersized

Too Many

Work Order June-05-12 3:36:59		317		*853	317*					Page 7
Revision ID: Item Name: Cro	05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1*	Accept	*N90004 Cust Item ID:	010 () *	Setup Sta	I)	IS1* IS2*
Reference: Approvals: Pr	rocess Plan	- ~	*1* Date: Date:	Tooling: SPC (Y/N):	Customer: Date: Date:		1	Run Sta	!/	JR1* JR2*
Sequence ID/ Work Center ID 230 *230* Crosstubes Crosstubes		up. A/R Prosea 2- Lightly sc with 41058 v 3-Install supp D407-667-24 A/R Sco	Batch: 12244/EXP: 1/3 uff the bonded area using wash 'n' wipe port with Scotch-Weld DI 5 using installaition jig I teh-Weld DP460 Batch: EXP:	a 320 grit sand paper and 2460 and install clamps as DT9025. Torque clampsas	clean the area per DEO Dwg per dwg 12 07 27	# Plan Code	Accept Qty	Qty	Reject Number	

QC5- Inspect part completeness to step on W/O

0.00

240

Memo

0.00

Quality Control

B 1207.31 0 11:01:31

									DQA:	Date:	•
NCR: Yes	/ No				WORK ORDER NON-0	CONFOR	MANCE / UF		QA Closed:	Date:	•
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		d. Eng. Coor. re/Packaging Supplier Other	Engineering Quality
Root				Descri	ption of work order update	Initial	Ad	tion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Offset/Setup Other Process Supplier Training Unauthorized							-				

FAULT CATEGORY Landing Gear General Hardware Maintenance Bending Passes Below Min Breaking Burrs Set-up Supplier Centre Not Concentric to O/S Missing Contamination Mislabeled Temperature/Cure Size/Length Off-Set Cracks Cut Too Short Documentation/Data Crushed/Crimp at Bending Weld Spinning Orientation Misread Wrong Stock Pulled Out of Calibration Inspection Strip in Tube Threading Finish Wrong Inspection Incomplete Out of Sequence Other Outside Dimensions Positioned Wrong **Drill Holes** Inspection Unqualified Other Misaligned Instructions Incomplete/Unclear Ripples on Inner Bend Over/Under tolerance Torque Waves in Extrusion Ovalized Jigs/Fixtures/Tooling Part Lost Turning Sequence Over/Undersized Kit Incorrect Part Moved Wave/Twist in Tube Too Many Kit Missing Raw Material

270 Packaging

Packaging

Packaging

Memo

Identify and in kanban rack Location:

0.00

0.00

Page 8

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		d. Eng. Coor. re/Packaging Supplier Other	Engineering Quality
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Offset/Setup Other Process Supplier Training								•			

General **Landing Gear** Hardware Maintenance Bending Passes Below Min Breaking Burrs Set-up Mislabeled Supplier Centre Not Concentric to O/S Missing Contamination Off-Set Temperature/Cure Cracks Size/Length Cut Too Short Crushed/Crimp at Bending Documentation/Data Orientation Misread Weld Spinning Wrong Stock Pulled Out of Calibration Inspection Strip in Tube Threading Finish Out of Sequence Inspection Incomplete Wrong Other Positioned Wrong **Drill Holes** Inspection Unqualified **Outside Dimensions** Other Misaligned Instructions Incomplete/Unclear Over/Under tolerance Ripples on Inner Bend **Torque Waves in Extrusion** Ovalized Jigs/Fixtures/Tooling Part Lost Over/Undersized Kit Incorrect Turning Sequence Part Moved Wave/Twist in Tube Too Many Kit Missing Raw Material

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

Unauthorized

Quality Control

June-05-12 3:36:59 PM Item ID: D407-667-205 Accept *N900040100* Setup Start **Revision ID:** Crosstube Aft Item Name: Start Qty: 1.00 *1* **Start Date:** 05/06/2012 **Cust Item ID: Required Date:** 19/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run **Process Plan:** Approvals: Date: **Tooling:** Date: Stop QC: _. Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Reject Reject Plan Accept **Work Center ID** Description Qty Qty Run Hours Code Number Stamp 280 QC21- Final Inspection - Work Order Release 0.00 *280* QC 0.00 Memo

Insp.

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WORK Orde	···				Rework	1		Skid-tube	Crosstube	٦	Proc	d. Eng. Coor.		Engineering
Part N	lo.				Scrap	1		Machining	Small Fab			e/Packaging		Quality
T dit i		-			Use-as-is	1 1		noforming	Finishing	٦	i	Supplier		
NCR N	lo.				Work Order Update	1		Large Fab	Composite	┨		Other		
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Root				Descri	iption of work order update	I	nitial	Ac	tion		Sign &			
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ļ		ed Wrong	,	<u> </u>	Drill Holes	-	· ·	on Unqualified	<u> </u>	7	Outside Dim	1	<u> </u>	Other
ŀ		on Inner E		Γ	Misaligned			ions Incomplete/	Unclear –	T	Over/Under		L	1
		Waves in		n	Ovalized			ures/Tooling			Part Lost			
					1									

Kit Incorrect

Kit Missing

Part Moved

Raw Material

Turning Sequence

Wave/Twist in Tube

Over/Undersized

Too Many

Picklist Print

June-05-12 3:37:02 PM

Work Order ID: 85317

Parent Item:

D407-667-205

Parent Item Name: Crosstube Aft

85317 *D407-667-205*

> **Start Date:** 05/06/2012 Start Qty: 1.00

Required Date: 19/06/2012

Required Qty: 1.00

Comments:

IPP Rev:C 05.09.02 Add holes for compatibility with Bell SkidtubesKJ/JLM 07-02-19

IPP Rev:D Added Magnobond, Rubber Cushion & Clamps

JLM

****CHANGE TO CHG 005 - IF USING D2894-1 B35578 OR GREATER**** IPP Rev:E 08-05-22 add comment in seq. 6 and QC15 and QC5 DD verified

by:EC

IPP Rev:F 08-06-12 add comment in seq. 24 DD verified by:EC

IPP Rev:G 08-08-19 revE as per dwg DD verified by:EC

IPP Rev H 09.01.06 ECN 08-562 EC verified by:DD IPP Rev:I 10.04.07 revise route seq. in bom DD verified by:JLM IPP Rev J 11.04.26

removed abrasion strip ecn 11-551 EC verified

by:DD

LG052

72644

11.10.03 DEO D407-667-245-F-2 DD verf:EC

	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D407-667-205TRN		Manufactured	No		,	110	Each	0.0000	1	1			
D407-667-	205TR	!N				25	J B84	10P	**	, , <u>S</u>	A0	12-07-	17
AN960JD516	NAS1149D0563J	Purchased	No			230	Each	0.0000	18	18			0
AN960.ID5 Washer	16								**	<u></u>	11957	16	a
D2873-043		Manufactured	No			230	Each	40.0000	2	2			
D2873-043	3								**		A8 1	12-7-	25
				Location		Loc (<u>Oty</u>	Loc Code					

40

2 38

IPP REV:K

										DQA:	Date:	: <u> </u>
NCR: Y	es / No				WORK ORDER NON-C	CON	FORM	MANCE / UPI	DATE		_	
										QA Closed:	Date:	•
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	lo			·	Rework Scrap Use-as-is		ľ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	•	d. Eng. Coor. re/Packaging Supplier	Engineering Quality
NCR N	lo				Work Order Update]		Large Fab	Composite	j	Other	
Root				Descri	ption of work order update	ln	itial	Act	tion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data		Ţ										
Equip/Tooling												
Operator												
Material												
Offset/Setup		İ	ļ									
Other												
Process						1						
Supplier						İ						
Training			1]		
Unauthorized			<u> </u>			<u> </u>						
						AULT	CATE					
Landir	ng Gear			_	Hardware	$\overline{}$		General	_	1	_	7
	Bending Passes Below Min				Breaking	$\boldsymbol{\vdash}$	Burrs			Maintenan	ce	Set-up
	Centre N	ot Conce	ntric to	o/s	Missing	\vdash	Contam		_	Mislabeled		Supplier
	Cracks				Size/Length	\mathbf{H}	Cut Too			Off-Set		Temperature/Cure
	Crushed/			g	Spinning	-		entation/Data		Orientation	<u> </u>	Weld
	Inspectio	n Strip in	Tube		Threading	\vdash	Finish			Out of Calib	<u> </u>	Wrong Stock Pulled
	Other				Wrong	-	•	on Incomplete	<u> </u>	Out of Sequ	_	7
	Positione	_		<u></u>	Drill Holes	\vdash	•	on Unqualified		Outside Dim	<u> </u>	Other
	Ripples o			<u> </u>	Misaligned	-		ions Incomplete/l	Jnclear .	Over/Under	tolerance	
	. Torque V	Vaves in I	Extrusio	n	Ovalized	l lì	ligs/Fixt	ures/Tooling		Part Lost		

Kit Incorrect

Kit Missing

Part Moved

Raw Material

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

Turning Sequence

Wave/Twist in Tube

Over/Undersized

Too Many

Picklist Print

June-05-12 3:37:02 PM

Work Order ID: 85317

D407-667-205

85317

Parent Item Name: Crosstube Aft

D407-667-205

Start Date: 05/06/2012

2

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

Page 2

D2873-045

Parent Item:

Nut Plate Assembly

Manufactured

230

Each

33.0000

2 **

Al 12-7-25

D2894-1

D2894-1

2.750 Support

Manufactured

Manufactured

No

82947

Location

LG052

33 33 230 Each

Loc Oty

7 0000

Loc Code

**

12.07.27

D3190-1 *D3190-1*

Chafing Shield

Location Loc Qty LG052 75212 82007 6 230 Each

41.0000

Loc Code

**

A 12-7-28

Loc Code Location Loc Qty LG053 23 75947 23 LG055 18 72576 18

2

June-05-12 3:37:02 PM

Shop Packet Print

Page 2

										DQA:	Date	: <u>·</u>
NCR: Y	es / No				WORK ORDER NON-C	CONF	FORM	MANCE / UPI	DATE			
										QA Closed:	Date	•
Work Orde					DISPOSITION AGAINST DE			EPARTMENT/PROCESS				
Work Orde					Rework	7	Skid-tube Crosstube		Crosstube	Prod. Eng. Coor.		Engineering
Part No.					Scrap	┪ ┃	Machining Small Fab			Rec/Store/Packaging		Quality
, a					Use-as-is	┪╽.		noforming	Finishing	1	Supplier	1 1
NCR N	lo.	*			Work Order Update	1	Large Fab Composite		Composite		Other	
Root				Descri	ption of work order update		tial	Act		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material		į										
Offset/Setup											1	
Other												
Process		ļ					ļ					
Supplier	-	1										
Training	<u>-</u>											
Unauthorized		<u> </u>	<u>.</u>		F	AULT	CATE	GORY				
Landir	ng Gear	-			Hardware			General				
	Bending I	Passes Be	elow Mir	, [Breaking	Пв	urrs			Maintenan	ce \lceil	Set-up
	Centre N				Missing	C	ontam	ination		Mislabeled		Supplier
	Cracks				Size/Length	C	ut Too	Short		Off-Set		Temperature/Cure
	Crushed/	Crimp at	Bending	3	Spinning		ocume	entation/Data		Orientation	Misread	Weld
	Inspectio	n Strip in	Tube		Threading	Fi	inish			Out of Calib	ration	Wrong Stock Pulled
i	Other				Wrong	∐ lr	rspecti	ion Incomplete		Out of Sequ	ence	
	Positione	d Wrong	;		Drill Holes		-	ion Unqualified		Outside Dim		Other
	Ripples o	n Inner B	Bend		Misaligned	∐ Ir	nstruct	ions Incomplete/l	Jnclear	Over/Under	tolerance	
	Torque V	Vaves in I	Extrusio	n	Ovalized	Ji	gs/Fixt	tures/Tooling		Part Lost		

Kit Incorrect

Kit Missing

Part Moved

Raw Material

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

Turning Sequence

Wave/Twist in Tube

Over/Undersized

Too Many

June-05-12 3:37:02 PM

Work Order ID: 85317

Parent Item:

D407-667-205

Parent Item Name: Crosstube Aft

85317

D407-667-205

Start Date: 05/06/2012

2

Required Date: 19/06/2012

Start Qty: 1.00

**

Required Qty: 1.00

D3595-063-450

D3595-063-450

RUBBER CUSHION

Manufactured

230

179.8095

W 12.01.27

<u>Location</u>	<u>Lo</u>	c Qty	Loc Code			
LG		60				
82511		60				
LG051		109.7				
80161		1.7				
84715		108				
MAT052	10.1	09474				
67353		2				_
68893		6				
70113		0.56				
71354		0.2				
74113	0.3	49474				
75597		1				_
	230	Each	144.0000	14	14	_

Each

MS20601-AD4W8

Purchased

No

**

Al 12-7-25

MS20601-AD4W8 RIVET

Location	Loc Qty	Loc Code
LG051	33	
121017	33	
ST314	100	
121827	100	
ST322	11	
121255	11	

(14)

DQA:	Date:	•
	•	

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date:	•	
Work Orde	ır.				DISPOSITION			AGAINST DE	PARTMENT,	ARTMENT/PROCESS		
Part No				Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Prod. Eng. Coor. Rec/Store/Packaging Supplier Other		Engineering Quality		
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Da	te Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Offset/Setup Other Process Supplier Training Unauthorized												
Unauthorized						AULT CATE	GORY				<u> </u>	
Landir	ng Gear				Hardware		General					
Centre Not Concentric to O/S Cracks Si Crushed/Crimp at Bending Inspection Strip in Tube Other Positioned Wrong Ripples on Inner Bend Torque Waves in Extrusion			Breaking Missing Size/Length Spinning Threading Wrong Drill Holes Misaligned Ovalized Over/Undersized	Cut Too Docum Finish Inspect Instruct	entation/Data ion Incomplete ion Unqualified tions Incomplete/ tures/Tooling	'Unclear	Maintenan Mislabeled Off-Set Orientation Out of Calib Out of Sequ Outside Dim Over/Under Part Lost Part Moved	Misread ration ence	Set-up Supplier Temperature/Cure Weld Wrong Stock Pulled Other			
		/Twist in Tu	ho		Too Many	Kit Miss	sing		Raw Materi:	 al		

NCR:

Yes / No

June-05-12 3:37:02 PM

Work Order ID: 85317

Parent Item:

MS21920-22

D407-667-205

Parent Item Name: Crosstube Aft

85317 *D407-667-205*

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21920-22

Clamp(per MIL-DTL-8783C)

Purchased

No

No

230

Each

48.0000

**

12-7-28

Location		Loc	Qty	Loc Code						
LG			l							
	119545		1					_		
LG050			47							
	116207		7					_		
	117506		1					_		
	118186		8							
(120631		31				(4)	_		
		230	Each	123.0000		2	2	- []		
					**			M	12.0	1.27

MS21920-25

Clamp(per MIL-DTL-8783C)

Purchased

Location	Loc Qty	Loc Code
LG050	75	
116264	2	
117998	4	
118142	4	
119339	2	
119746	2	
120475	7	
120920	54	
LG051	48	
121583	48	

								DQA.	Date	
NCR: Yes	s / No			WORK ORDER NON	-CONFOR	MANCE / UF		QA Closed:	Date:	•
Work Order:				DISPOSITION	DISPOSITION AGAINST			DEPARTMENT/PROCESS		
Part No.		-		Rework Scrap Use-as-is	⊸ ।	Skid-tube Machining moforming	Crosstube Small Fab Finishing		d. Eng. Coor. re/Packaging Supplier	Engineering Quality
NCR No.				Work Order Update		Large Fab	Composite		Other	
Root			ľ	Description of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data							-			
Equip/Tooling										
Operator										
Material										
Offset/Setup	_									
Other	_									
Process	_								1	
Supplier	_									
Training	_				1					
Unauthorized										
					FAULT CATI	EGORY				
Landing	Goar			Hardware		General		•		

Burrs

Finish

Contamination

Cut Too Short

Documentation/Data

Inspection Incomplete

Inspection Unqualified

Jigs/Fixtures/Tooling

Kit Incorrect

Kit Missing

Instructions Incomplete/Unclear

DO 4 -

Maintenance

Orientation Misread

Outside Dimensions

Over/Under tolerance

Out of Calibration

Out of Sequence

Mislabeled

Off-Set

Part Lost

Part Moved

Raw Material

Set-up

Weld

Other

Supplier

Temperature/Cure

Wrong Stock Pulled

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Cracks

Other

Bending Passes Below Min

Crushed/Crimp at Bending

Inspection Strip in Tube

Positioned Wrong

Turning Sequence

Wave/Twist in Tube

Ripples on Inner Bend

Torque Waves in Extrusion

Centre Not Concentric to O/S

Breaking

Missing

Size/Length

Threading

Misaligned

Over/Undersized

Ovalized

Too Many

Drill Holes

Spinning

Wrong

ST340

No

Purchased

121541

AN5-34A

Location Loc Qty Loc Code 339 25 121181 25 ST339 39 120422 39

250

100

100

Each

64.0000

**

120422

/c/s/010

Page 5

Dart Ae	·····		1410	RK ORDER CHANG	EC			•	
W/O:	STEP	DD	OCEDURE CHAI	By	T	Date Qty	Approval Chief Eng /	Approva	
DATE	SIEP	PRO	OCEDURE CHAI	4GE	Ву	<u> </u>	Date Gty	Prod Mgr	QC Inspecto
		·					,	·	
Part No):	PAR #:	Fault Cate	jory:	_ NCR: Ye	s N	o DQA :	Date: _	
		lution:	1						
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	CR)			
		Description of NC		Corrective Action Sec	· D		Verification	Approval	Approva
DATE		Description of NC					Verification	Approval	Approva
	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sig	n & ate	Verification Section C	Approval Chief Eng	Approva QC Inspect
	STEP	Description of NC Section A	Initial		Sig				
	STEP	Description of NC Section A	Initial		Sig				
	STEP	Description of NC Section A	Initial		Sig				
	STEP	Description of NC Section A	Initial		Sig				
	STEP	Description of NC Section A	Initial		Sig				
	STEP	Description of NC Section A	Initial		Sig				

NOTE: Date & initial all entries

H:\fORMS\Quality Assurance\approved QA\NCRWO RevE

June-05-12 3:37:03 PM

Work Order ID: 85317

Parent Item:

MS21042L5

D407-667-205

Parent Item Name: Crosstube Aft

Purchased

No

85317 *D407-667-205*

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

	200 Eden	**	012/8/01
Location	Loc Qty	Loc Code	•
300	500		
121652	500		

1.409.000

Location	Loc Qty	<u>Loc Code</u>	
300	500		
121652	500		
ST300	909		***************************************
108827	8		
116105	5		
116548	43		
117611	18		
119109	827		119107
17651	8		

Each

250

Dart Ae	rospace Li	t d							
W/O:			WO	ORK ORDER CHAN	IGES				
DATE	STEP	PRO	OCEDURE CHA			y	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
				- `					
Part No		PAR #:	Į.				**.		
NCR:				ER NON-CONFOR					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Description Chief Eng		ign & Date	Verification Section C	Approval Chief Eng	Approva QC Inspecto
		•							
		·							:
1					1			}	

MOTE: Date & initial all entries

H:\fORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	85317
Description: Crosstube High Aft (407)	Part Number:	D407-667-205
Inspection Dwg: D407-667-245 Rev: F		Page 1 of 1

Min

23.39

45.79

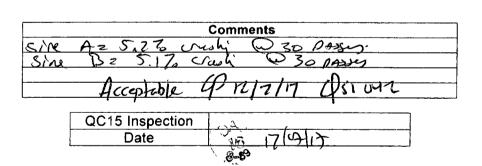
Max

23.65 46.05

Required Dimension

Height 1/2 Span

	Angle	54	56	ĺ
	Total Span	91.58	92.100	
	0.210= 3.972		0.70([†] 3.	484
	5.2%		5.17.	? ·
23.56° SCAD	7.04		7.099	53.40



9/240"

Date	Change	Revised by	Approved
07.02.06	New Issue	KJ/JM	
09.06.22	Dwg Rev updated	KJ	
11.08.22	Dimensions updated	KJ IA	
11.09.30	Dimensions updated	KJ (XX	F
-	07.02.06 09.06.22 11.08.22	07.02.06 New Issue 09.06.22 Dwg Rev updated 11.08.22 Dimensions updated	07.02.06 New Issue KJ/JM 09.06.22 Dwg Rev updated KJ 11.08.22 Dimensions updated KJ

I te m	QTY -245	PART NUMBER	DESCRIPTION
1	Х	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	□2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

D

С

1) MATERIAL: MANUFACTURED FROM D6011-115

FINISHED LENGTH = 112.91+0.020

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART OSI 005 4.2

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

UNITS: INCHES UNLESS OTHERWISE NOTED.

BREAK SHARP EDGES: 0.005 TO 0.010 MAX. IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.

WEIGHT: 27.7 lbs

WEIGHT: 27.7 IIIS PART IS SYMMETRIC ABOUT CENTERLINE RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.

BENDING IS 5% BASED ON O.D.

11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

13) INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE

NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS.

ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.

14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, PER QSI 035.

16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.

17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY RETURN TO ENGINEERING **UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE

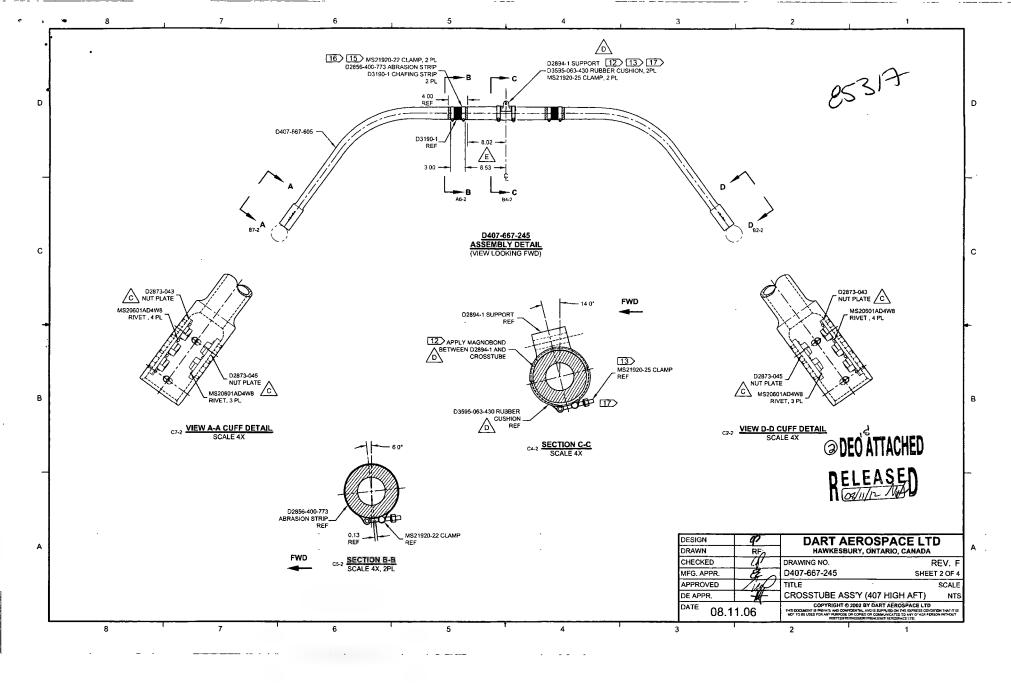
WORK ORDER M LJ 12/06/05 DEO ATTACHED

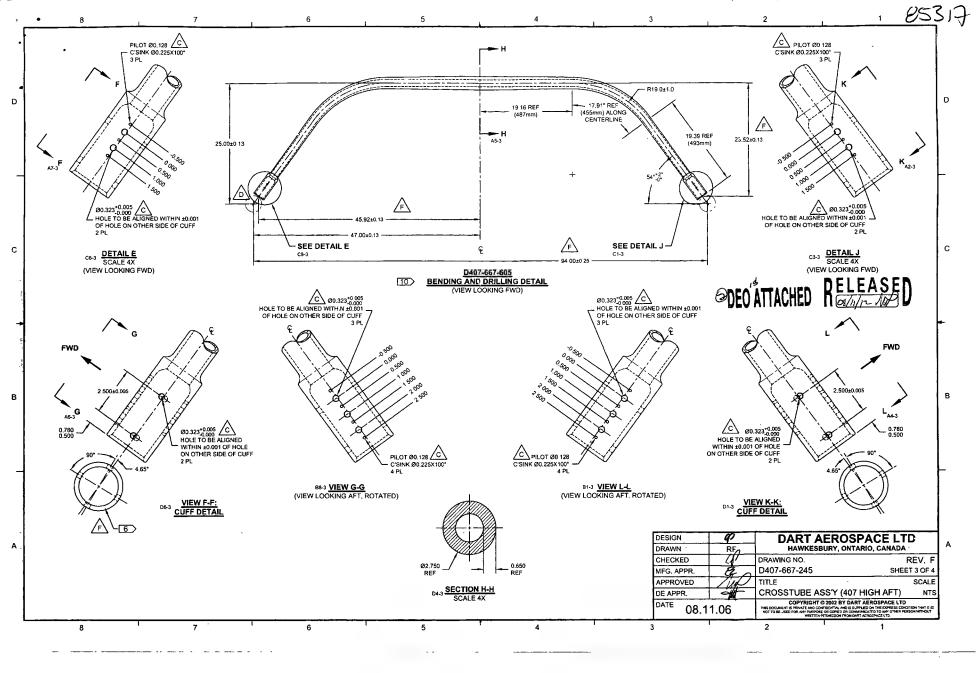
F	RELOCA	MAT NOTES TO ATED FLAG # 6 ED REF. & ADI	RF	08.11.06		
E	REORG TO CU REASO ELIMIN	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: FAR#08-21 AND ECN#1225				
D	ORIEN	IEW FOR OEM TATION OF CI BRASION STR ON	PH	07.02.07		
С	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES			PH	05.07.26	
В	ADD CHAFING SHIELD			CP	03.05.21	
Α	NEW ISSUE				02.05.13	
REV.	/. DESCRIPTION			BY	DATE	
DESIGN		P	DART AEROSPA	ACE	LTD	
DRAWN		RF ₂	HAWKESBURY, ONTAR	IO, CAN	ADA	
OUTOW		777	2244010			

CHECKED DRAWING NO. REV. F D407-667-245 MEG. APPR SHEET 1 OF 4 APPROVED SCALE CROSSTUBE ASS'Y (407 HIGH AFT) COPYRIGHT @ 2002 BY DART AEROSPACE LTD DATE

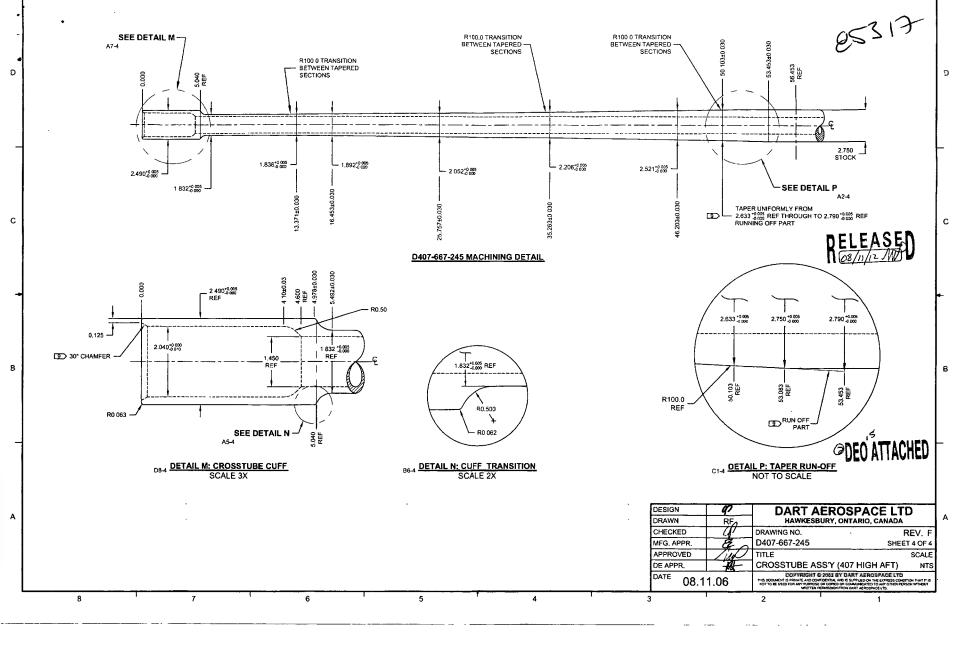
08.11.06

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_ 							/ -
DRAWING	1	•	REV. F	DART AEROSPACE	LTD D.E.O. NO.	SHEET NO.	SCALE
D407-6	67-245 CROS	STUBE ASSY (407 H	HIGH AFT)	ENGINEERING OR	DER D407-667-245-F-1	SHEET 1 OF 2	NTS
DRAWN		CHECKED	q)	MFG. APPR.	APPROVED /	DE APPR.	
DATE	11.04.08	DATE 11	1.04.12	DATE 11.04.12	DATE 11.04.12	DATE 11-04-12	

PURPOSE:

REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

Item	Qty -245	Part Number	Description
3	0	D2856-400-773	ABRASION STRIP

WAS:

3	2	D2856-400-773	ABRASION STRIP

NOTES 2 AND 15, SHEET 1 ARE AMENDED AS FOLLOWS:

18:

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT

15) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3190-1 CHAFING SHIELDS AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEALED D3190-1 CHAFING SHIELDS ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

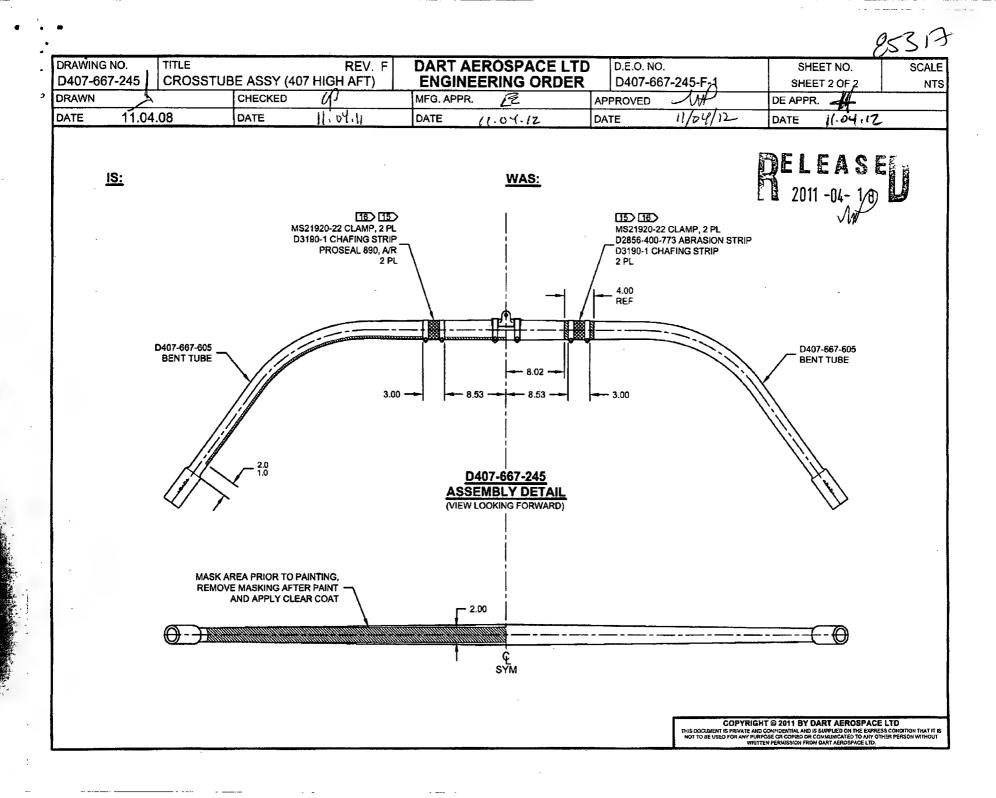
WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.



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	DRAWING NO.	TITLE	REV. F	DART AE	ROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
•	D407-667-245	CROSSTUBE ASS'Y (407 HIGH AFT)	ENGINE	ERING ORDER	D407-667-245-E-2	SHEET 1 OF	NTS
•	DRAWN 97	CHECKED	ASS	MFG. APPR.	Œ	APPROVED W	DE APPR.	
i	DATE 11.09.	07 DATE	11.09.19	DATE	11-09-19	DATE 11.09.19	DATE 11.09.19	

PURPOSE:

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

CHANGE:

IS:

Item	Qty -245	Part Number	Description	(3)
12	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD	

WAS:

12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023
			ADHESIVE (TEXTRON/BELL SPEC. 299-947-100,
			TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 17, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

WAS:

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



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LIQUID PENETRANT TEST REPORT

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CUENT	500 - 4	For Sport		DATE	1420/1	2 TIME AM D	4 PM 🗆
CLIENT ATTENTION	AIN	1 (1D4		ACUREN JOB NO.	121/19	9-12-0	0295
ADDRESS	12-70	IRFA DEEL	57.	PO/WO No.	17504 -		
DUILOG	HANKE SU	Sanci n.)		WORK LOCATION	Saule	2 TO	
	1/ TENKE SE	-w-1 (0W		ACCEPTANCE STE	Fetm 1417/00	REV./DATE 2	7,05
Project		F.P. I. c	caps (L	STABES	7011111111111		
TEM(S) EXAMINED		<u> </u>		2003) 2003			
CLEINIG) EVAININED			- 6				
JOB DESCRIPTION	ON	PROCEDURE NO. LT	©©⊋_Rev./Date	2008	TECHNIQUE NO. LT-	A REV./DATE	CC &
Part N o.	SEE!	CESCILTS		MATERIALALLA		THICKNESS VALLO	THE RESERVE OF THE RE
SCOPE A	NETE	Loures LE	27 LID			YANWA?	et'
-	or PEFE	DONTHE		7	FACE 10	17.1	
TEST DETAILS		UN E-PL	Pull				
METHOD	⊅ FLUOR	ESCENT	VISIBLE	☑ WATER WASH	SOLVENT F	REMOVABLE D P	OST EMULSIFIED
FAMILY BRAND		FLUX		BLACK LIGHT S/N	16459 □ OUTPUT > 1	1000 μ W/cm² 🔲 An	MBIENT < 2 fc
PENETRANT	267	MINIMUM DWELL TIME			☐ FLASHLIGHT ☐ TROUBLE	LIGHT 🔲 OUTPUT>10	0 fc @ SURFACE
PENETRANT REMOV		MINIMUM DRY TIME	>10 Min.	OTHER	LABINO	CAL DUE DATE	Za 19 25
DEVELOPER TYPE	Non Aque	MINIMUM DWELL TIME	10 Min. DRY	LIGHT METER S/N	1 1098866	CAL DUE DATE	212
DEVELOPER TYPE TEST SURFACE	NON AQUE	OUS LI AQUEOUS	U DKI	L			
SURFACE CONDITION	As Groun	id 🗓 As W	/ELDED	☑ MACHINED	☐ SHOT BLASTED	Z CLEAN B	ARE METAL
	TURE - 4°C/20	0°F □ - 4°C	/ 20°F ⊤o 10°C/50°		☑ 10°C/50°F TO 52°C/		
RESULTS-	METRIC	☐ IMPERIAL)					
that all descriptions, comm representations or warrant data or other information p	Group Inc. to perform service tents and expressions of opin ieses. Acure Group Inc. is no	ion reflect the opinions or observe t assuming any responsibilities of	ations of Acuren Group Inc. the owner/operator and the	er no circumstances shall s based on information and owner/operator retains c	uch services extend beyond the perform assumptions supplied by the owner/open mplete responsibility for the engineerin rein exceed the amount paid for such se	ance of the requested services. Irrator and are not intended nor cog, manufacture, repair and use c	t is expressly understoo; an they be construed as
Standard of Care	provided, Acuren Group Inc.				ers performing such services in the same		arranty, expressed or
	NEATHE A #	Zi 1N	fua		I DT	R# E11738	3 Q
CLIENT REPRESE		Sheldon PRINT		SIGNATURE	REPORT	N# 2/// 30	
TECHNICIAN (SIGNA	ATURE):	1 10 1			REVIEWED BY	Y:	
NAME (PRINT):	M	KE ILS/		OND ===		NAME	INITIALS
	CGSB LEV		CGSB LE		LEVEL		

Change Record

Part Number <u>D407-667-265</u>
Description <u>407 AFF</u> CROSS TUBE

Page ___ of ___

Ch-	Data	10	
Chg.	Date	By	Relevant Documents
000	02.06.04	d.	BOR DR-0206-667 REV. E
002	03.05.21		
we.	03.03.21	DS.	PER DR-DZG-667 Rev-F
003	05.09.09	KS	70 -0: 4:00
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004	07.02.14	AL.	70 70 11 11 11 11 11 11 11 11 11 11 11 11 11
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005	07.11.07	A	70 221 117 D = 1-22-10
005	01,11,0.7	77	DR-D206-667 Rev. F (D2894 Rev. C)
006	08.08.18	TX.	7/1-7/1701-0
000	00100118	13	D407-667-245 Pes. E (ECN 1225)
007	11.04.P	ATT_	NOCES V ASSESSMENT
00 (11,04.71	(2)	DS19550 Pav. A. DED-D407-669-F-1
			(ECN 11-551)
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